

## ABSTRACT

A triangularly shaped flexible bottle having a gusseted body section, and a neck section comprised of narrowed portions of the side panels and gusset of the body section, with a fitment in the neck section. The bottle has a flat bottom that may be created by tapering the webs forming the bottom at about 30 degrees. The body has a triangular cross section when filled, but may be contoured in the vertical direction. A process for fabricating the bottle is also disclosed which involves feeding webs, including a side gusset, creating perimeter seals around only the top portion of the bottle, inserting the fitment from the input end of the machine in the direction of web travel, forming the remainder of the perimeter seams, detaching the nascent bottle from the web, and sealing the neck section of the bottle to the fitment by clamping the neck section with a heated clamp, and preferably repeating the seal operation at a different radial angle. Sealing the fitment by application of ultrasonic energy is also disclosed.